

Date: Tuesday, 23/09/2008 1:00:27 PM
 User: Julie Lecocq

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEARPAD |
| Job Number : 42258 | |
| Estimate Number : 12784 | |
| P.O. Number : | Part Number : D35649 |
| This Issue : 23/09/2008 S.O. No. : | Drawing Number : D3564 REV D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : D |
| Previous Run : 41465 | Material : |
| Written By : | Due Date : 05/10/2008 Qty: 20 Um: Each |
| Checked & Approved By : <u>JLD 08.9.23</u> | |
| Comment : Est Rev:A New Issue 07-03-08 ec Est Rev:B As per Rev C 07-07-09 JLM Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|--|
| 1.0 | M304S16GA | 304/316 Sheet .063 |
| | | |
| Comment: Qty.: 1.1550 sf(s)/Unit Total : 23.1000 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: <u>109057</u> <u>B 8-10-7</u> | | |
| 2.0 | WATER JET | FLOW WATER JET |
| | | |
| Comment: FLOW WATER JET 1-Cut as per Dwg D3564 ***** (D3564-1F)***** Dwg Rev: <u>D</u> Prog Rev: <u>D</u> <u>B 8-10-7</u> 2-Deburr if necessary <u>B 8-10-7</u> | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 8-10-7</u> | | |
| 4.0 | QC8 | SECOND CHECK |
| | | |
| Comment: SECOND CHECK <u>Soslu/08</u> <u>(722)</u> <u>counters</u> | | |
| 5.0 | BRAKE NC | NC BRAKE |
| | | |
| Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 <u>SB</u> <u>28/10/08</u> | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 1:00:27 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 42258

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

Form Joggle as per Dwg D3564 on brake using Jig DT 8157

8B 08/10/08 (22)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

S 08/10/08 (22) counter

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch

A/R 2059B Hardcoat

M109303

Weld hardcoat as per Dwg D3564

EL 8-10-10 (22)

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/10/08 (22) counter

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/08 (22)

10.0

POWDER COATING

POWDER COATING



M106442



(22x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:50
320 OF
11:20

M 08/10/15

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FP 08/10/15

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-19

FP 08/10/15 (22)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 1:00:27 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 42258

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/16 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W. Davis

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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|------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 42258 |
| Description: Wearshoe | | Part Number: D3564-9 |
| Inspection Dwg: D3564 | Rev: D | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 3.227 | +/-0.010 | 3.225 | X | | | |
| 2.432 | +/-0.010 | 2.438 | X | | | |
| 2.50 | +/-0.030 | 2.50 | X | | | |
| 6.000 | +/-0.010 | 6.005 | X | | | |
| 12.104 | +/-0.010 | 12.104 | X | | | |
| 18.000 | +/-0.010 | 18.000 | X | | | |
| 18.000 | +/-0.010 | 18.000 | X | | | |
| 18.00 | +/-0.030 | 18.00 | X | | | |
| 9.00 | +/-0.030 | 9.00 | X | | | |
| 11.50 | +/-0.030 | 11.50 | X | | | |
| 0.300 x 0.300 | +/-0.010 | .303 x .307 | X | | | |
| Ø0.188 | +0.005/-0.001 | .192 | X | | | |
| R0.375 | +/-0.010 | .375 | X | | | |
| 0.063 | +/-0.010 | .059 | X | | | |
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|---------------------------------|--------------------------------|----------------------------|-----|
| Measured by: [Signature] | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 8-10-7 | Date: 6/10/08 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|----------------------|-------------|
| A | 08.01.16 | New Issue | KJ/EC/DD [Signature] | [Signature] |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



RELEASED

07.09.04 *ff*



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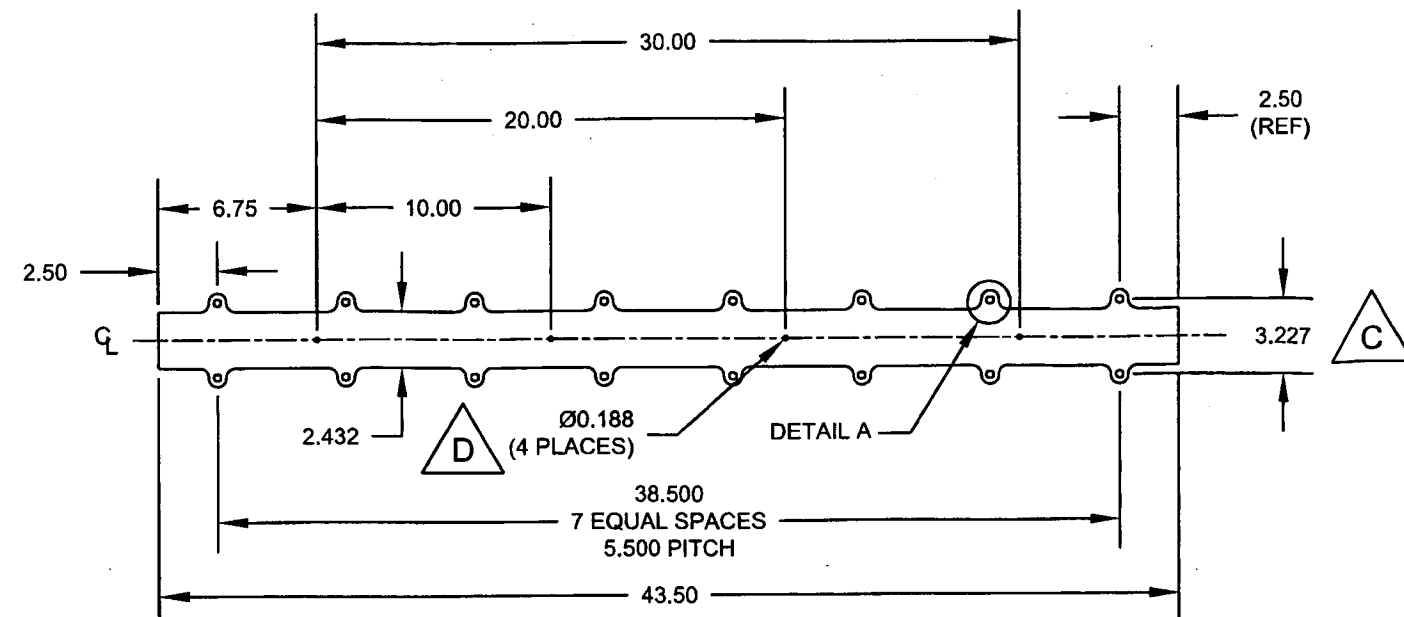
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:

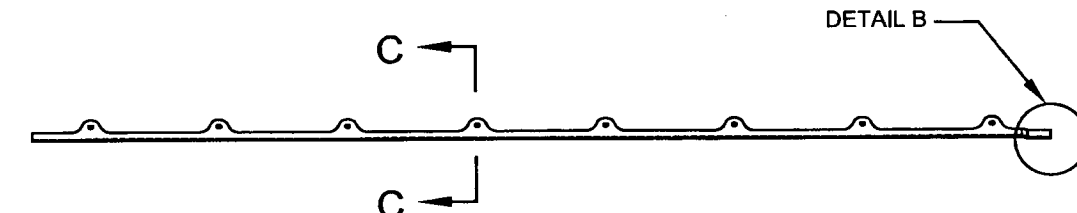
| | |
|----------|----------|
| D3564-1 | 1.85 lbs |
| D3564-3 | 1.85 lbs |
| D3564-5 | 1.93 lbs |
| D3564-7 | 1.26 lbs |
| D3564-9 | 1.85 lbs |
| D3564-11 | 1.85 lbs |
| D3564-13 | 0.38 lbs |
| D3564-15 | 0.80 lbs |

| | | | |
|------------|--|--|--------------|
| D | UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE | CB | 07.08.21 |
| C | MOVE TAB OUTBOARD, DETAIL A | PH | 07.04.17 |
| B | ADD AMS 5513 AND AMS 5524 | PH | 07.03.20 |
| A | NEW ISSUE | PH | 06.12.18 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CB | | |
| CHECKED | PH | DRAWING NO. | REV. D |
| MFG. APPR. | PH | D3564 | SHEET 1 OF 3 |
| APPROVED | PH | TITLE | SCALE |
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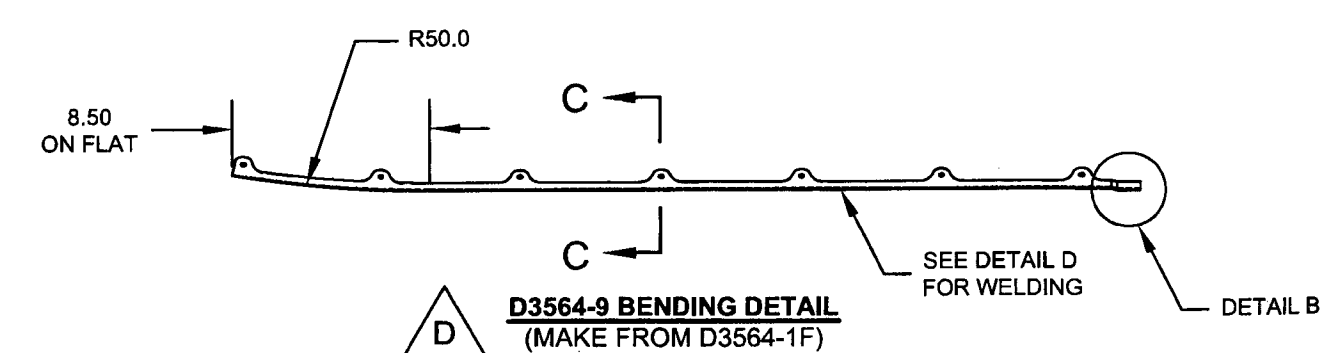
8 7 6 5 4 3 2 1



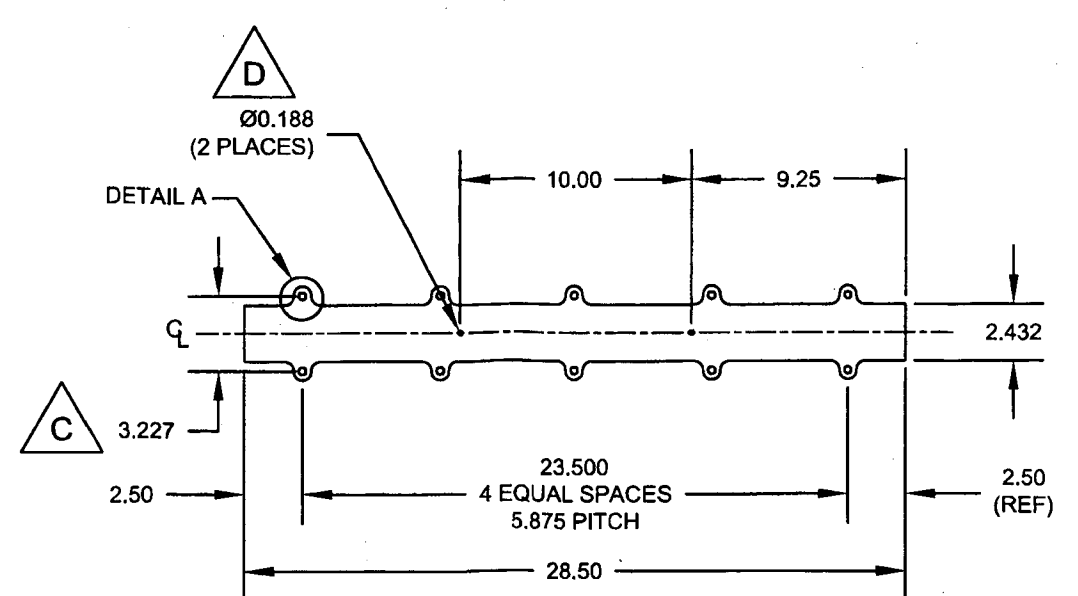
D3564-5F FLAT PATTERN



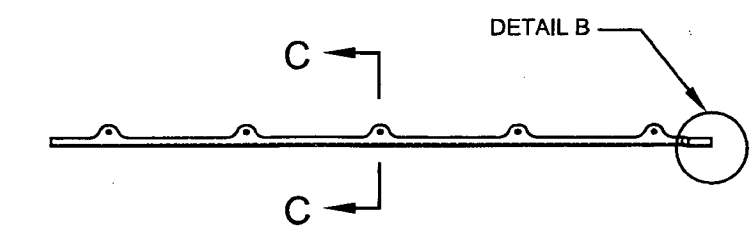
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



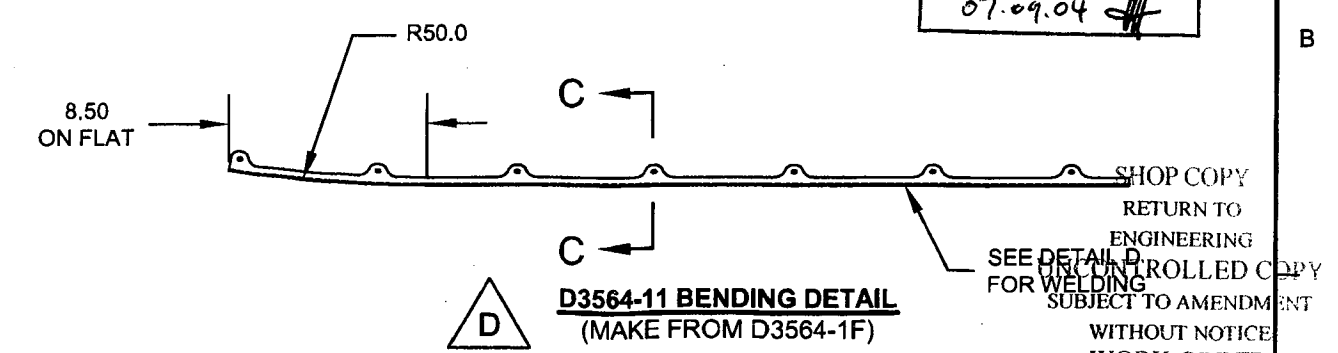
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



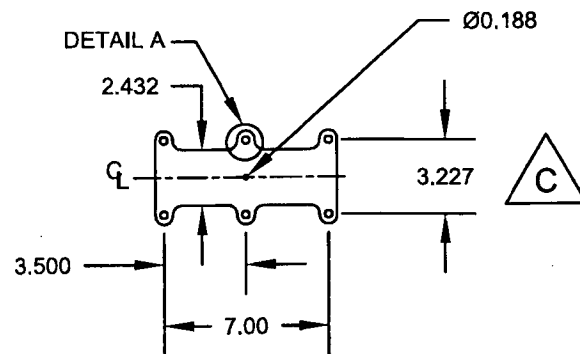
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

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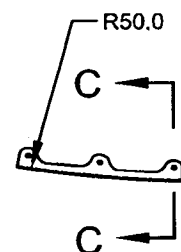
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| DRAWN | C.B. | | |
| CHECKED | PH | DRAWING NO. | REV. D |
| MFG. APPR. | PH | D3564 | SHEET 2 OF 3 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | WEARSHOE | 1:8 |
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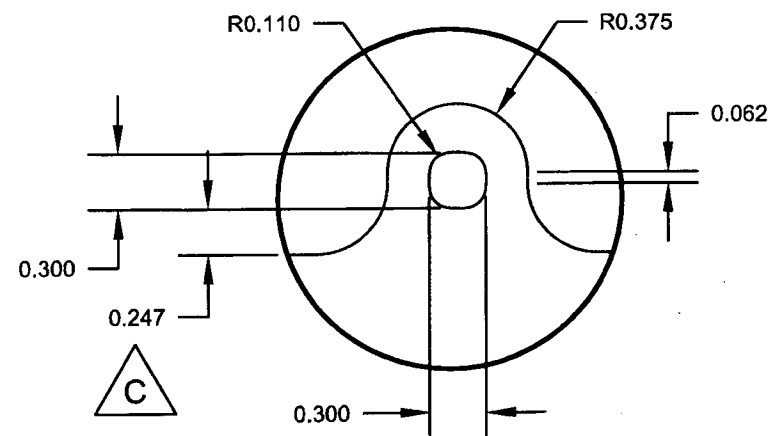
8 7 6 5 4 3 2 1



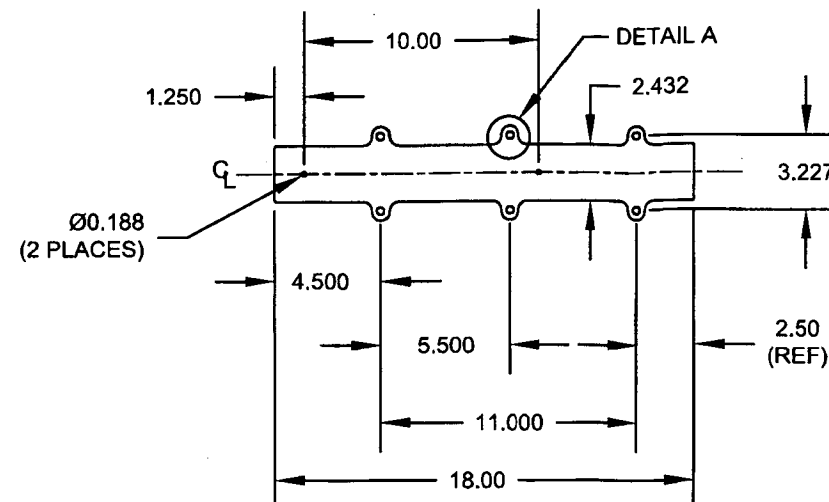
D3564-13F FLAT PATTERN



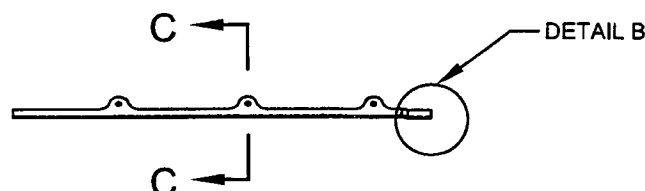
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



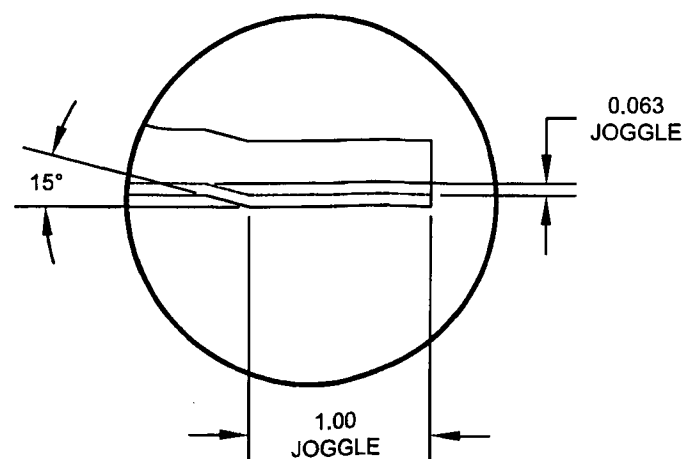
DETAIL A
SCALE 1:1



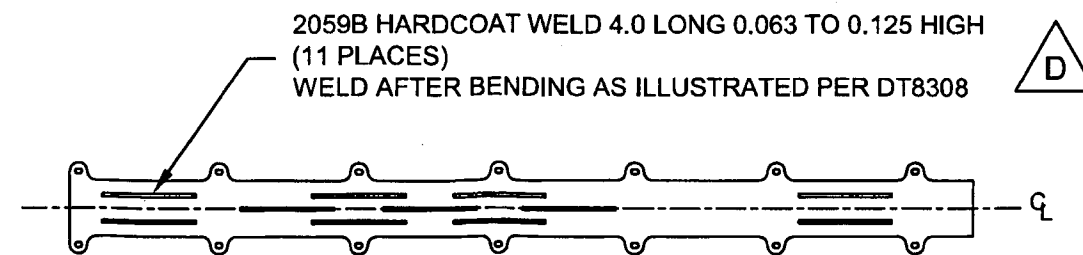
D3564-15F FLAT PATTERN



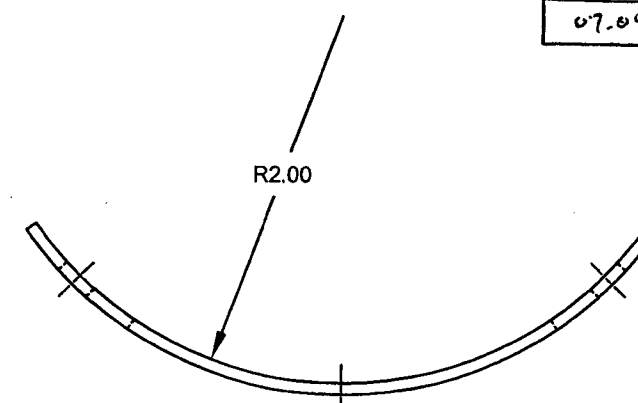
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



DETAIL B
SCALE 1:1



DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



SECTION C-C
SCALE 1:1

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| MFG. APPR. | 21 | D3564 | SHEET 3 OF 3 |
| APPROVED | 16 | TITLE | SCALE |
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